

Work Order ID 84086

84086

Page 1

Wednesday, May 02, 2012 1:08:54 PM

Item ID: D2207-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Housing Weldment
 Start Date: 5/2/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/8/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: P Date: 12-05-2 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2207	Rev C								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1-Chamfer D2208 and D2207-1 before welding2-Weld as per dwg D22073-Grind welds flush as per Dwg D2207								
110	QC10- Inspect visual per QSI004- ground welds	0.00							
110									
QC	Memo	0.00							
Quality Contr-									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

④ 12.6.20
 4 ∅ Ae 12.06.21
 12.7.12
 12/02/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Housing Weldment

Start Date: 5/2/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

Drill holes using DT8557 as per Dwg D2207

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

Quality Control

0.00

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

Hand Finishing

0.00

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 7:30	0.00							
	FINISH TIME: 8:00								
	320°F								
170	QC3- Inspect Part Finish	0.00							
170									
QC									
Quality Control	Memo								
180	Large Fab	0.00							
180									
Large Fab									
Large Fab	Memo								
	Install AK57-1032-130 as per Dwg D2207								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Revision ID:

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Item Name: Housing Weldment

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Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 4.00

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(+)			
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							12/7/13
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							OK 12/7/13 ME 12-07-13

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, May 02, 2012 1:08:58 PM

Work Order ID: 84086

84086

Parent Item: D2207-041

D2207-041

Parent Item Name: Housing Weldment

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C 01.10.18 Added Step 10 and 11 SM
IPP D 07-10-11 REV C dwg DD verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130

Purchased

No

100

Each

2,212.000

4

16

AI S7-1032-130

**

W 5/2/12

Insert

Location

Loc Qty

Loc Code

ST280

127

117717

27

118966

22

119775

78

ST282

2085

119530

73

120181

12

121444

2000

x 16

D2208

Manufactured

No

100

Each

1.0000

2

8

D2208

**

EL 12-5-20

Endcap, Torquemeter

Location

Loc Qty

Loc Code

WA020

1

38144

1

D2207-1

Manufactured

No

180

Each

0.0000

1

4

D2207-1

**

B 12-6-20

Housing Body

84087 x4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

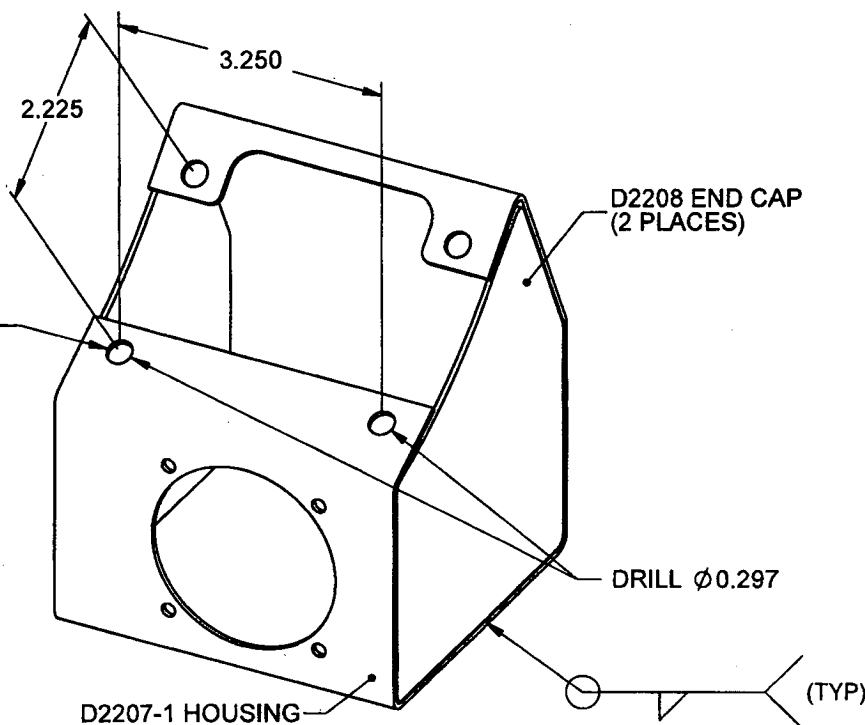
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AFTER FINISH, INSTALL
AKS7-1032-130 OR
ALS7-1032-130 OR
AKS4-1032-130 OR
ALS4-1032-130
(4 PLACES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84084



RELEASED
07.08.29

12-05-8

D2207-041 HOUSING ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2207	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HOUSING	1:2
DATE	07.06.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

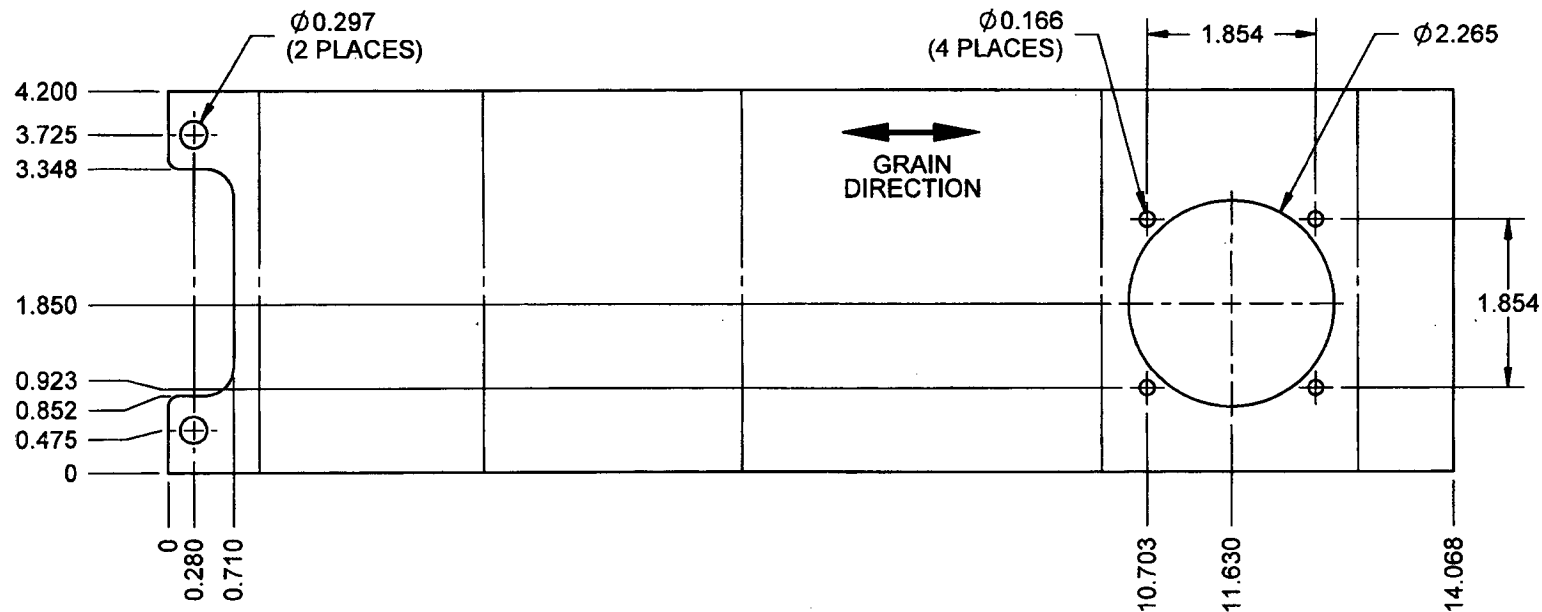
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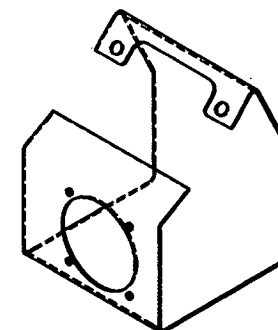
NOTE: Date & initial all entries



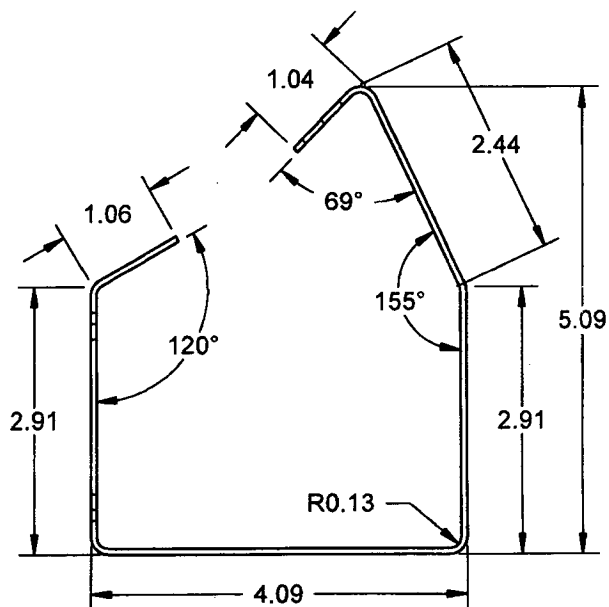
D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



ISOMETRIC VIEW
(SCALE 1 : 4)



D2207-1 BENDING DETAIL

RELEASED

07.08.29

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D2207	SHEET 2 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	HOUSING	1:2
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